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RBST2812-P
Job Sheet 189411



Part No: RBST2812-P

Job Qty: 4 pcs

Part Name: Portable Tri-Roller Staking Tool



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/24/19

Job Tracking No:

Due Date: 2/28/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG RBST2800-P Rev. 1 IPP Rev. A 18.06.21 new issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Small Fab - 1	4 pcs	2/28/19		0.00	2.00	Small Fab - 1		
							Small Fab - 2		MLC
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
110	QC 6	4 pcs	2/28/19		0.00	0.00	QC 6 - 38		
							QC 6 - 42		
							QC 6 - 9		DAS
							QC 6 - 68		FEB 12 2019 68
							QC 6 - 61		9-89
130	Packaging 3-1 - Stock - B4B	4 pcs	2/28/19		0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		DAS
							Packaging 3 - 7 - B4B		28
							Packaging 3 - 8 - B4B		7-89
							Packaging 3 - 9 - B4B		
							Packaging 3 - 10 - B4B		
							Packaging 3 - 11 - B4B		
							Packaging 3 - 12 - B4B		
							Packaging 3 - 13 - B4B		
							Packaging 3 - 14 - B4B		
							Packaging 3 - 15 - B4B		
							Packaging 3 - 16 - B4B		
							Packaging 3 - 17 - B4B		
							Packaging 3 - 18 - B4B		
							Packaging 3 - 19 - B4B		



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Container No: S150310



Part: RBST2812-P

Job No: 189411

Serial No/Batch: S150310

Revision: 1

Inspector:

Exp Date:

Instructions:

Date: 02/02/19

					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
140 QC 21 - FG	4 pcs	2/28/19	0.00 0.00	QC 21 - FG - 21	QC 21 - FG - 70	DAG FEB 12 2019 21

Part Op 100 - (Small Fab) 1-Assemble as per DWG sheet 1. ***NOTE*** - Apply a light coat of corrosion prevention compound to Descriptions: assembly (LPS 1/2) See deviation. See note 1 and 2.

110 - (QC6- All purchased or subcontracted products)

130 - (Identify as per dwg & Stock Location: _____) Identify and Stock

140 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
54 92383A202	Roll Pin	4 pcs (1 ea)	100-Small Fab - 1	5089124
58 95065A150	Distorted Thread Lock Nut	4 pcs (1 ea)	100-Small Fab - 1	5089130
43 99142A410	Internal Snap Ring	4 pcs (1 ea)	100-Small Fab - 1	5089123
78 CS075-H1	Crest to Crest Flat Wire Wave Spring	4 Ea (1 ea)	100-Small Fab - 1	5093475
34 NTA-411	Bearing	4 Ea (1 ea)	100-Small Fab - 1	3X 5003507 1X 503 3972
34 NTA-613	Bearing 13/16" Od X 3/8" Id (Applied)	4 Ea (1 ea)	100-Small Fab - 1	5071979
RBST2812-P-1	Base	4 pcs (1 ea)	100-Small Fab - 1	5121008
RBST2812-P-11	Dual Seat	4 pcs (1 ea)	100-Small Fab - 1	5122412
RBST2812-P-13	Receiver	4 pcs (1 ea)	100-Small Fab - 1	5121969
RBST2812-P-15	Tensioner	4 pcs (1 ea)	100-Small Fab - 1	5122415
RBST2812-P-3	Retainer	4 pcs (1 ea)	100-Small Fab - 1	5119966
RBST2812-P-5	Roller	12 pcs (3 ea)	100-Small Fab - 1	5111469
RBST2812-P-7	Cap	4 pcs (1 ea)	100-Small Fab - 1	5119984
RBST2812-P-9	Stud	4 pcs (1 ea)	100-Small Fab - 1	5122419
TRA-411	Washer	8 Ea (2 ea)	100-Small Fab - 1	5033973
TRA-613	Washer 13/16" Od X 3/8" Id (Applied)	8 Ea (2 ea)	100-Small Fab - 1	5141336

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	92383A202	4	98	0
	95065A150	4	96	0
	99142A410	4	50	0
	CS075-H1	4	9	0
	NTA-411	4	44	0
	NTA-613	4	9	0
	RBST2812-P-1	4	9	0
	RBST2812-P-11	4	10	0
	RBST2812-P-13	4	9	0
	RBST2812-P-15	4	9	0
	RBST2812-P-3	4	9	0
	RBST2812-P-5	12	17	0
	RBST2812-P-7	4	9	0
	RBST2812-P-9	4	9	0
	TRA-411	8	78	0
	TRA-613	8	10	0

Part Specifications

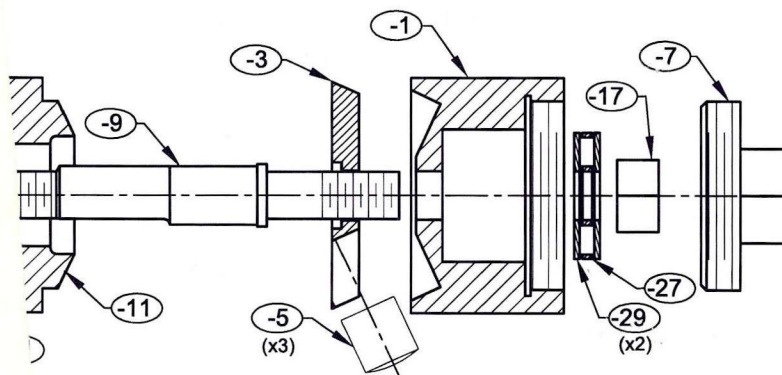
Specifications could not be found.

Plex 1/24/19 8:36 AM Dart.lajeunesse.marie

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*Guillaume les a
checker et a remis
un peu d'anti-peige

sont
correct :-)*



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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 189411 MWS
19-01-29

NOTES

1. -5 ROLLERS AND -3 RETAINER MUST TURN SMOOTHLY ON -1 BASE WHEN ASSEMBLED.
2. FLAT END OF -5 ROLLERS MUST FACE THE CENTER OF TOOL WHEN ASSEMBLED.

ASSY QTY	ASSY QTY	B/O	PART #	UNIT QTY	DESCRIPTION	MAT.	B/O INFORMATION OR SPECIFICATIONS	Pg.
			-1	1	BASE		SEE CHART	2
			-3	1	RETAINER		SEE CHART	3
			-5	3	ROLLER		SEE CHART	4
			-7	1	CAP		SEE CHART	5
			-9	1	STUD		SEE CHART	6
			-11	1	DUAL SEAT		SEE CHART	7
			-13	1	RECEIVER		SEE CHART	8
			-15	1	TENSIONER		SEE CHART	9
		B/O	-17	1	DISTORTED THREAD LOCK NUT	STEEL	1/4-20 UNC x 7/32 Ht. MCMaster-CARR #95065A150	1
		B/O	-19	1	CREST TO CREST FLAT WIRE WAVE SPRING	STEEL	.750 OD., .550 ID., WIRE THICK. .013, THREE TURNS SMALLLEY RING CO. #CS075-H1	1
		B/O	-21	1	INTERNAL SNAP RING	STEEL	Ø7/8 BORE MCMaster-CARR #99142A410	1
		B/O	-23	1	THRUST BEARING (SPRING SIDE)	STEEL	Ø3/8 ID. x 13/16 OD. x 5/64 WIDTH APPLIED (TIMKEN #NTA-613)	1
		B/O	-25	2	BEARING WASHER	STEEL	Ø3/8 ID. x 13/16 OD. x 1/32 WIDTH APPLIED (TIMKEN #TRA-613)	1
		B/O	-27	1	THRUST BEARING	STEEL	Ø1/4 ID. x 11/16 OD. x 5/64 WIDTH APPLIED (TIMKEN #NTA-411)	1
		B/O	-29	2	BEARING WASHER	STEEL	Ø1/4 ID. x 11/16 OD. x 1/32 WIDTH APPLIED (TIMKEN #TRA-411)	1
		B/O	-31	1	ROLL PIN	STEEL	Ø3/32 x 3/8	N/S
ASSY #								

BEARINGS & TOOLS COVERED	
BEARING #	TOOL #
206-010-470-101	RBST2812-P

RED BARN MACHINE

TITLE RBST2800-P SERIES FOR BELL BEARINGS
PORTABLE TRI-ROLLER SWAGING TOOLS

DWG NO.	SEE CHART ABOVE FOR TOOL No.	REV 1
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		DRAWN BY: PERRITT
TOLERANCES ON:		APPROVED <i>D Med</i>
DECIMALS	XXX ± .005	HEAT TREAT
FRACTIONS	± 1/32	FINISH
ANGLES	± 5°	SPEC
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR. .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING		USED ON BEARING
SCALE NTS		SEE CHART
DATE 11-9-09	SHEET 1 of 9	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS			
		Skid-tube ☐ Machining ☐ Large Fab ☐	Cross tube ☐ Small Fab ☐ Finishing ☐	Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐	Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐
Date :	Sequence #:	QTY Affected :			MRB (QSI042)
Description Work Order Deviation		Disposition			Completed By
					Lead hand / Supervisor
					QC / QA Coordinator
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY			
		☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled	☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function	☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up	☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread
		Other/Details:			